

Work Order ID 150618

Monday, August 29, 2016 2:48:37 PM

150618

Page 1

Item ID: D139-799-211

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Quick Release Maintenance Step, LH

Start Date: 8/25/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/7/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

DAS

Date:

AUG 30 2016

Tooling:

Date:

QC:

21
9-89

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D139-799	K	SEP 30 2016					DAS 21 9-89	16-10-05	
100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D139-799-211 CHG001 CHG002 as per ECN 16-657 dm								
							DAS 27 9-89	DEC 02 2016	
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
								SEP 30 2016	DAS 6 9-89
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
							DAS 27 9-89		

DEC 02 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Work Order ID 150618

Monday, August 29, 2016 2:48:38 PM

150618

Page 2

Item ID: D139-799-211

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Quick Release Maintenance Step, LH

Start Date: 8/25/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/7/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D139-799-211 Location: fg019								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
28
9-89
DEC 02 2016DAS
21
9-89
DEC 02 2016DAS
21
9-89
DEC 02 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

Monday, August 29, 2016 2:48:37 PM

Page 1

Work Order ID: 150618

150618

Parent Item: D139-799-211

D139-799-211

Parent Item Name: Quick Release Maintenance Step, LH

Start Date: 8/25/2016

Required Date: 9/7/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 15-07-08 JLM VERIFIED BY:DD IPP
REV:B as per NCR16-5959 DD VERIFIED BY:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5238-041		Manufactured	No				Each	0.0000		1			DAS 6 28 9-89
D5238-041									**	149670		SEP 30 2016	
Maintenance Step Assembly													
D5238-043		Manufactured	No				Each	0.0000		1			DAS 28 9-89
D5238-043									**	149693			
Lower Bracket, Aft													
D5238-045		Manufactured	No				Each	0.0000		1			DAS 28 9-89
D5238-045									**	149647			
Lower Bracket, Fwd													
D5245-1		Manufactured	No				Each	11.0000		1			DAS 28 9-89
D5245-1									**	SEP 30 2016	DAS 6 9-89		
Mounting Bolt													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST160		11							
				147223		11							
AN6H12A		Purchased	No				Each	24.0000		2			DAS 28 9-89
AN6H12A									**	SEP 30 2016	DAS 6 9-89		
Bolt										135530			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				Sr335		3							
				m132930		3							
				ST335		21							
				m134335		21							

Add as per ECN 16-657 DAS 27 9-89
D5245-7 x1
2m

153103

OCT 7 7 2016
NOV 25 2016
DAS 27 9-89

DAS 27 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Monday, August 29, 2016 2:48:37 PM

Page 2

Work Order ID: 150618

150618

Parent Item: D139-799-211

D139-799-211

Parent Item Name: Quick Release Maintenance Step, LH

Start Date: 8/25/2016

Required Date: 9/7/2016

Start Qty: 1.00

Required Qty: 1.00

AN6H13A Purchased No

Each 45.0000 1

AN6H13A

Bolt

**

SEP 30 2016

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST335

45

m132930

2

m134257

13

m134370

30

NAS1149D0663J Purchased No

Each 982.0000 5

NAS1149D0663J

Washer

**

SEP 30 2016

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST260

227

M131618

227

ST260a

600

M135464

600

ST263

150

M135135

150

ST269

5

M126334

5

Monday, August 29, 2016 2:48:37 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause				FAULT CATEGORY					
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

Monday, August 29, 2016 2:48:37 PM

Page 1

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 8/25/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 9/7/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: AUG 30 2016 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

[illegible]

5.0 PARTS LIST

Qty -011	Qty -012	Qty -017	Qty -019	Qty -112	Qty -211	Qty -212	Qty -213	Part Number	Description
X								D139-799-011	MAINTENANCE STEP KIT, LH
	X							D139-799-012	MAINTENANCE STEP KIT, RH
		X						D139-799-017	CARGO FLOOR PROTECTOR KIT
			X					D139-799-019	CABIN FLOOR PROTECTOR KIT
				X				D139-799-112	MAINTENANCE STEP WITH GRAB BAR KIT, RH
					X			D139-799-211	QUICK RELEASE MAINTENANCE STEP KIT, LH
						X		D139-799-212	QUICK RELEASE MAINTENANCE STEP KIT, RH
							X	D139-799-213	QUICK RELEASE MAINTENANCE STEP PROVISIONS KIT
		2						D3580-1	JOGGLE BRACKET
		2	8					D3628-1	CUPPED WASHER
1								D4092-041	MAINTENANCE STEP ASSEMBLY
	1							D4092-042	MAINTENANCE STEP ASSEMBLY
			1					D4130-1	FWD CABIN FLOOR PROTECTOR
			1					D4130-3	AFT CABIN FLOOR PROTECTOR
		1						D4130-5	FWD CARGO FLOOR PROTECTOR
		1						D4130-7	CENTER CARGO FLOOR PROTECTOR
		1						D4130-9	AFT CARGO FLOOR PROTECTOR
		1						D4153-1	JOGGLE BRACKET
		1						D4153-3	JOGGLE BRACKET
			4					D4153-5	CLAMP PLATE
		2						D4166-1	PLACARD, MAX LOAD
				1				D4526-042	MAINTENANCE STEP ASSEMBLY, RH
					1			D5238-041	MAINTENANCE STEP ASSEMBLY
						1		D5238-042	MAINTENANCE STEP ASSEMBLY
					1	1	1	D5238-043	LOWER BRACKET, AFT
					1	1	1	D5238-045	LOWER BRACKET, FWD
					1	1	1	D5245-1	MOUNTING BOLT
2	2			2	2	2	2	AN6H12A	BOLT
2	2			2	1	1	1	AN6H13A	BOLT
6	6			6	5	5	5	NAS1149D0663J	WASHER (or AN960JD616)

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D139-799 REV. L OR LATER APPROVED REVISION AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D139-799 REV. 11 OR LATER APPROVED REVISIONS

REF. FAA STC: SR02138SE
REF. TCCA LOA: C-11-0841
REF. EASA STC: 10038656
REF. ANAC STC: 2012S02-13
REF. JCAB STC: STC-425-TYO

1.0 PURPOSE

The D5245-1 Mounting Bolt provided with kit P/Ns D139-799-211/-212/-213 at CHG 001 is too short for installation on AB/AW139 model aircraft that are SAR configured or reinforced for installation of a hoist. The purpose of this DART Service Instruction (DSI) is to add a longer bolt (P/N D5245-7) to kit P/Ns D139-799-211/-212/-213 at CHG 002 and later.

Customers who have already purchased kit P/Ns D139-799-211/-212/-213 at CHG 001 can contact DART to obtain the DSI 9761-011 Mounting Bolt Kit.

Qty -011	Part Number	Description
X	DSI 9761-011	MOUNTING BOLT KIT
1	D5245-7	MOUNTING BOLT

2.0 INSTALLATION AND MAINTENANCE

The D5245-7 Mounting Bolt installs on AB/AW139 model aircraft that are SAR configured or reinforced for installation of a hoist only. The D5245-7 Mounting Bolt should be installed and maintained in accordance with the same instructions as the D5245-1 Mounting Bolt as outlined in IIN-D139-799 and ICA-D139-799 respectively.

3.0 WEIGHT AND BALANCE

This change has a negligible effect on weight and balance.

4.0 PARTS LISTS

For D139-799-211/-212 Quick Release Maintenance Step Kits, LH/RH and D139-799-213 Quick Release Maintenance Step Provisions Kit, modify the Parts List of IIN-D139-799 and ICA-D139-799 as follows:

Qty -011	Qty -012	Qty -017	Qty -019	Qty -112	Qty -211	Qty -212	Qty -213	Part Number	Description
X								D139-799-011	MAINTENANCE STEP KIT, LH
	X							D139-799-012	MAINTENANCE STEP KIT, RH
		X						D139-799-017	CARGO FLOOR PROTECTOR KIT
			X					D139-799-019	CABIN FLOOR PROTECTOR KIT
				X				D139-799-112	MAINTENANCE STEP WITH GRAB BAR KIT, RH
					X			D139-799-211	QUICK RELEASE MAINTENANCE STEP KIT, LH
						X		D139-799-212	QUICK RELEASE MAINTENANCE STEP KIT, RH
							X	D139-799-213	QUICK RELEASE MAINTENANCE STEP PROVISIONS KIT
					1	1	1	D5245-7	MOUNTING BOLT (ADD)

APPROVED

A	NEW ISSUE	ML	16.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	DSI 9761	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	MOUNTING BOLT KIT	NTS
DATE	16.10.20	COPYRIGHT © 2016 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	